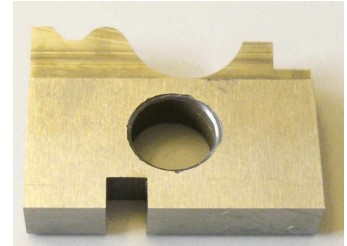















Singlesided Insert with ref. Notch

A08-300

The rectangular Insert is clamped using the PPC System (Precision Pin Clamping). All the sides are free for any grinding of profile, chipbreaking or referenceface operations. This specific inserts has a reference face, a reference notch and a chipbreaker space of 10 degrees. Profilegrinding is based on the VSW grinding technology, where the sides of the V-shaped wheel fit tangential to the straight faces and convex parts of the profile. The distortion calculation follows the chipspace hook angle.



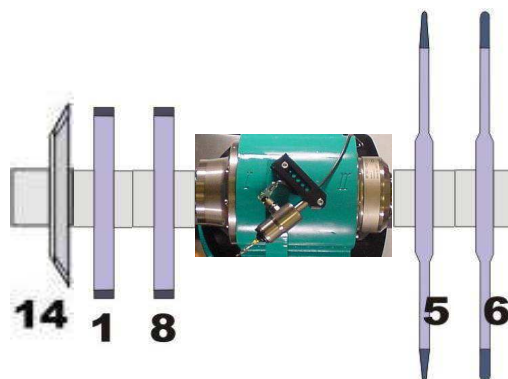
1. Cycletime for production

Tool specifications							
Diameter 16 mm, Cutting edges 1, Length of cutting edge 20 mm							
Material HM							
Operations							
Feed [mm/Min]	2000	25	65	110	60	60	60
Power [kW]		2	1	1	1	1	1
Cutting feed [m/s]		18	24	30	18	18	18
Used wheels							
Grinding time [s]	13	53	82	42	48	43	64
Total cycle time	5 Min 46						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1 Ø300 1A1 D76
 5 Ø300 14EE1 D91 VSW
 6 Ø300 14EE1 D46 VSW
 14 Ø125 1V1 D64
 8 Ø125 1A1 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 4.2, DXQ-Insert

responsible engineer: OP, 19.3.07

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